Dart Aerospace Ltd.

Date: Tuesday, 9/4/2007 11:29:47 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FLANGE PLATE
Job Number	: 34402			
Estimate Number	: 12153			
P.O. Number	: N/A		Part Number	: D34797
This Issue	: 9/4/2007	S.O. No. : N/A	Drawing Number	: D3479 REV A
Prsht Rev.	: NC		Project Number	: N/A
First Issue	: N/A	Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 34090		Material	: N/A
Written By	:		Due Date	: 10/4/2007 Qty: 6 Um: Each
Checked & Approved By	: [signature] 07.09.04			
Comment	: Est Rev:A New Issue 06-02-02 JLM			

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M304S26GA	304/316 0.018 SHEET

Comment: Qty.: 0.0750 sf(s)/Unit Total : 0.4498 sf(s)
304/316 0.018 SHEET
Batch: M105490 HB 07-09-06

Seq. #:	Machine Or Operation:	Description :
2.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
Cut as per Dwg D3479
Dwg Rev: A
Prog Rev: A HB 07-09-06 (6)

Seq. #:	Machine Or Operation:	Description :
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

HB 07-09-06

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Seq. #:	Machine Or Operation:	Description :
4.0	QC8	SECOND CHECK

Comment: SECOND CHECK CR 07/09/06 (x6) counted

Seq. #:	Machine Or Operation:	Description :
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr if necessary. MF 07-09-06 (6)

Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP SB 07/09/28 (6)

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______ **PAR #:** ______ **Fault Category:** ______ **NCR:** Yes (No) **DQA:** D **Date:** 07/10/30

QA: N/C Closed: ______ **Date:** ______

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Tuesday, 9/4/2007 11:29:47 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE PLATE

Job Number: 34402

Part Number: D34797

Job Number:

Seq. #:	Machine Or Operation:	Description :
7.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: GA

mf 07-10-29 (6)

Seq. #:	Machine Or Operation:	Description :
8.0	QC21	FINAL INSPECTION/W/O RELEASE

(6)

Comment: FINAL INSPECTION/W/O RELEASE

07/10/29

Job Completion

07.10.29

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34402
Description: Flange Plate	Part Number:	D3479-7
Inspection Dwg: D3479 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

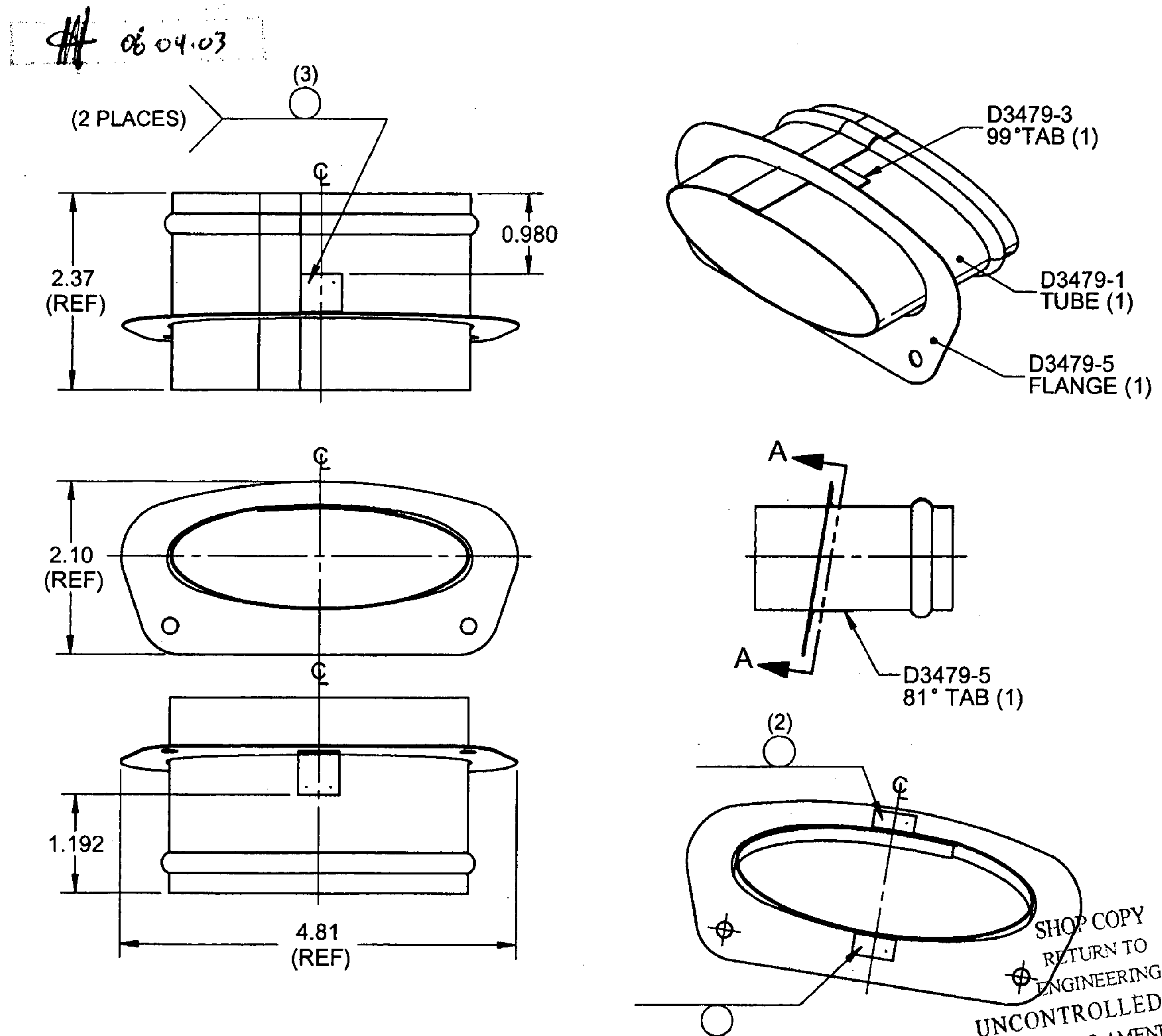
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.81	+/-0.030	4.808	*			
0.560	+/-0.010	.553	*			
0.350	+/-0.010	.350	*			
Ø0.191	+0.005/-0.001	.194	*			
1.845	+/-0.010	1.845	*			
2.13	+/-0.030	2.123	*			
0.018	+/-0.010	.019	*			

Measured by:	HB	Audited by:	[signature]	Prototype Approval:	N/A
Date:	07-09-06	Date:	07/09/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.02	New Issue	KJ/JLM [signature]	[signature]

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3479 — REV. A — SHEET 1 OF 4
DATE 06.01.19		TITLE INLET ADAPTER — SCALE 1:2
A	06.01.19	NEW ISSUE



D3479-041 INLET ADAPTER

SECTION A-A

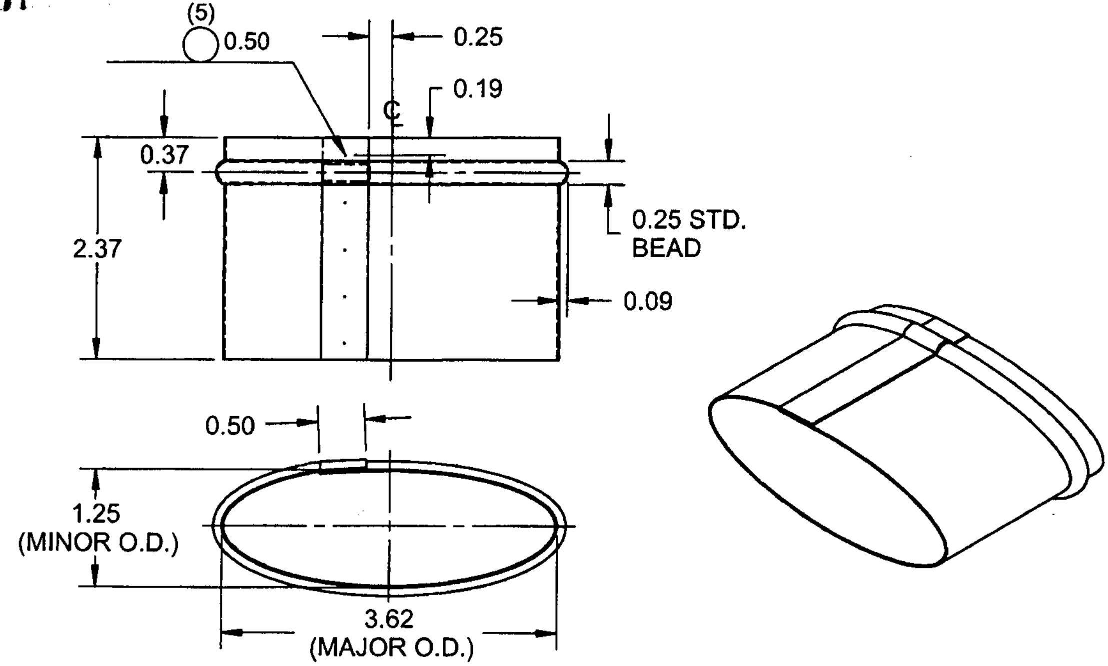
NOTES:

1) SPOT WELD PER DART QSI 018
2) FINISH: NONE
3) IDENTIFY WITH DART P/N D3479-041 USING FINE POINT PERMANENT INK MARKER
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

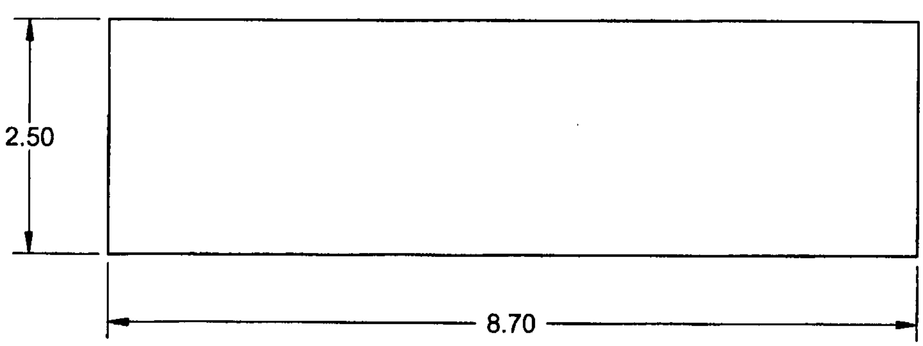
QTY -041	P/N	DESCRIPTION
X	**D3479-041**	**INLET ADAPTER**
1	D3479-1	TUBE
1	D3479-3	99 DEGREE TAB
1	D3479-5	81 DEGREE TAB
1	D3479-7	FLANGE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3479	REV. A SHEET 2 OF 4
DATE 06.01.19		TITLE INLET ADAPTER	SCALE 1:2

06.04.03



D3479-1 TUBE



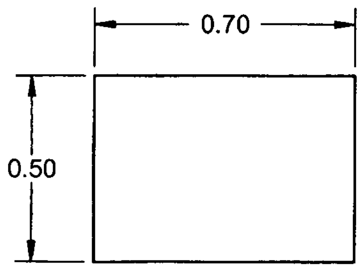
D3479-1F FLAT PATTERN

NOTES:

1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
 26 GAUGE SS (0.018 THICK)
 (REF. DART SPEC. M304S26GA)
2) SPOT WELD PER DART QSI 018
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3479 — REV. A — SHEET 3 OF 4
DATE 06.01.19		TITLE ADAPTER INLET — SCALE 2:1

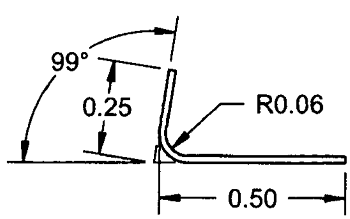
DART

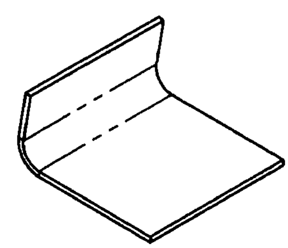


06.04.07

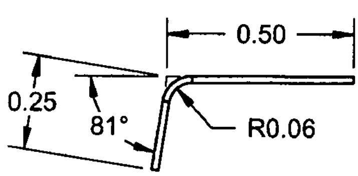
D3479-3F FLAT PATTERN

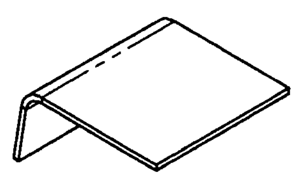
1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)





D3479-3 99 DEGREE TAB
(MAKE FROM D3479-3F FLAT PATTERN)





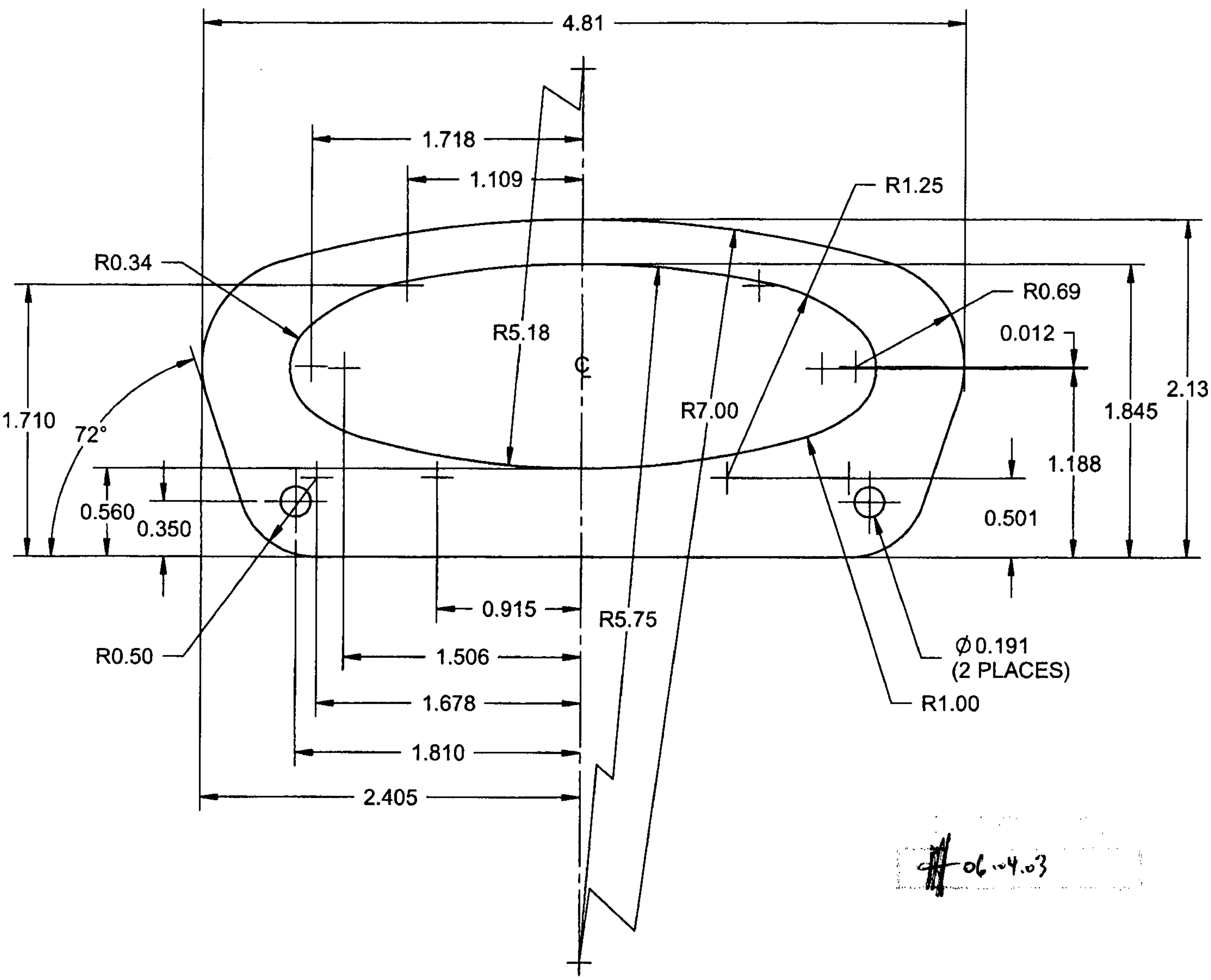
D3479-5 81 DEGREE TAB
(MAKE FROM D3479-3F FLAT PATTERN)

NOTES:

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3479 REV. A SHEET 4 OF 4
DATE 06.01.19		TITLE ADAPTER INLET SCALE 1:1

DART



D3479-7 FLANGE PLATE

NOTES:

1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
   26 GAUGE SS (0.018 THICK)
   (REF. DART SPEC. M304S26GA)
2) PART IS SYMMETRICAL ABOUT CENTERLINE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010